4 12:03:13 I	24353 PM		*1243	53*							Page 1
D3631-1			Accept	N900	040	100)*	Setup		*N	S1*
Washer		100	•						Stop	*N	S2*
	Start Qty: 50.00	*50*		Cust Item 1	ID:						
9/10/14	Req'd Qty: 50.00	<u>*50*</u>		Customer:							
Process Pla	an:MLS	Date: 14-09-17	Tooling:	D	ate:	_		Run	Start	*N	R1*
QC:		Date:	SPC (Y/N):						Stop	*N	R2*
)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept				Insp. Stamp
Rev	vision Nbr										
Rev	' A										
	PURCHASING		0.00	**			(a)	\mathcal{L}	Jne	=/12 1	(00
	Memo Issue P/O: <u>△</u> Master Carro	25843 Purchase Part Nu Certificate of conformity is re	0.00 mber: 95606A170Supplier: I equired	Мс				<u> </u>	7107	(/// /	<u>80</u>
	Receive & Inspect for Da	ımage & Mat'l Certs	0.00								
	Мето		0.00				_/	4	17/2	3 (20/_
-	Washer 9/10/14 9/10/14 Process Pla QC:	Washer 9/10/14 Start Qty: 50.00 9/10/14 Req'd Qty: 50.00 Process Plan: QC: Operation Description Revision Nbr Rev A PURCHASING Memo Issue P/O: Master Carre Receive & Inspect for Da Memo	Washer 9/10/14 Start Qty: 50.00 *50* 9/10/14 Req'd Qty: 50.00 *50* Process Plan:	Washer 9/10/14 Start Qty: 50.00 *50* 9/10/14 Req'd Qty: 50.00 *50* Process Plan:	Washer 9/10/14 Start Qty: 50.00 *50* Process Plan: MS Date: MS Tooling: Date: SPC (Y/N): D Operation Set Up/ Tool ID Operation Nbr Rev A O.00 PURCHASING Memo O.00 Issue P/O: 258/3 Purchase Part Number: 95606A170Supplier: Mc Master CarrCertificate of conformity is required Receive & Inspect for Damage & Mat'l Certs O.00 Memo O.00 Memo O.00 O.00 Memo O.00 O.00	Washer 9/10/14 Start Qty: 50.00 *50.00 Process Plan:	Washer 9/10/14 Start Qty: 50.00 *50 * 9/10/14 Req'd Qty: 50.00 *50 * Process Plan: MS Date: SPC (Y/N): Date: QC: Date: SPC (Y/N): Date: Operation Description Set Up/ Run Hours Rev A PURCHASING Memo 0.00 Issue P/O: 258/3 Purchase Part Number: 95606A170Supplier: Mc Master CarrCertificate of conformity is required Receive & Inspect for Damage & Mat'l Certs 0.00 Memo 0.00 Receive & Inspect for Damage & Mat'l Certs 0.00	Washer 9/10/14 Start Qty: 50.00 *50* Cust Item ID: 9/10/14 Req'd Qty: 50.00 *50* Customer: Process Plan:	Washer 9/10/14 Start Qty: 50.00 *50 * Cust Item ID: 9/10/14 Req'd Qty: 50.00 *50 * Customer: Process Plan:	Washer 9/10/14 Start Qty: 50.00 *50* Cust Item ID: 9/10/14 Req'd Qty: 50.00 *50* Customer: Process Plan: March Start Stop Date: Tooling: Date: Stop Operation Description Set Up/ Tool ID Tool # Plan Accept Reject Description Run Hours Rev A O.00 PURCHASING Memo 0.00 Issue P/O: 2524/3 Purchase Part Number: 95606A170Supplier: Mc Master CarrCertificate of conformity is required Receive & Inspect for Damage & Mat'l Certs 0.00 Memo 0.00 Revision Nor Damage & Mat'l Certs 0.00 Memo 0.00 Receive & Inspect for Damage & Mat'l Certs 0.00 Memo 0.00 Receive & Inspect for Damage & Mat'l Certs 0.00	Stop Stop

120

QC6- Inspect dimensions to drawing

0.00

120

Memo

0.00

Quality Control

DQA:			Date:						•					TRACE
						WORK ORDER NON	-CC	ONFO	RMANCE / UF					AEROSPACE
QA Closed:			Date:							V	Vork Order (ipdate only		
Work Orde	er:					DISPOSITION								
	-					Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.					Scrap	1	1	Machining	Small Fab	Pr	od. Eng. Coor.		Quality
	•					Use-as-is]	Thern	noforming	Finishing	Rec/St	ore/Packaging		Other
NCR N	۱٥.			**************************************		Suspected Unapproved]		Large Fab	Composite		Supplier	Ш	
Root	Ī				Desci	ription of work order update		nitial	Act	ion	Sign &			-
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material	Ш										1			
Operator												ļ		
Offset/Setup												1		
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Supplier														
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Landi	nø G	iear				General	17	OLI CA	I E O O I I I					
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		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain		ŀ		r tolerance	-	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire	F	Part Incorr			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Un	ngualified	Part Lost/I	/lissing	П	Weld
		Cuffs		•		Contamination		1 '	ions Incomplete/L	-	Part Move	d		Wrong Stock Pulled
	Crushing					Countersink		4	ned/off center		Positioned	Wrong		
	Heat Treat					Cut Too Short		Mislabe	eled		Power Los	s/Surge		Other
	Inspection Strip in Tube			Tube	Drawing		Misread	d	_					
		Marks/Ch	natter			Drill Holes		Off-set						
	Turning Sequence					Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tuk	е		Fit/Function		Out of 9	Sequence					

Work Ord September-11-		-		*124353*								
Item ID: Revision ID: Item Name:	D3631-1 Washer			Accept	*N900	040	10	N *	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date Reference:	9/10/14 e: 9/10/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item 1 Customer:	ID:					1 4	. 12
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^IV	R1* R2*
Sequence ID/ Work Center 1 130 *120* Packaging	TD	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qty	1	Reject Number	Insp. Stamp
		Memo		0.00				/00 x	← —	.14.1	14-	(

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

MUS 14:09-26

DQA:			Date:												"DART	
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		W۲	ork Order up	ndate only	\Box	AEROSPACE	
QA Closed.			Date.					AGAINST DEPARTMENT/PROCESS								
Work Orde	er:					DISPOSITION				AGAINST	DEI	PARIMENI	PROCESS .			
	•					Rework			Skid-tube	Crosstube			Water Jet	Ш	Engineering	
Part N	10.		<u>.</u>			Scrap			Machining	Small Fab			d. Eng. Coor.		Quality	
						Use-as-is		Therr	noforming	Finishing		Rec/Stor	re/Packaging		Other	
NCR N	10.	,				Suspected Unapproved]		Large Fab	Composite			Supplier	Ш		
Root					Desc	ription of work order update		nitial	Acti	ion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verificatio	<u>n</u>	QC Inspector	
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Landi	na (Gear				General	r A	OLI CA	TEGOK1							
Lanui	lig (Bending				Bend		Teolio/F	Program			Outside Dim	ensions		Pressure/Forced	
	┢	4 ~	ot Concer	ntric		BOM/Route	\vdash	Grain	108.4			Over/Under		\vdash	Set-up	
		Cracks	or concer	10110		Broken/Damage/Defect	\vdash	Hardwa	are		_	Part Incorre		\vdash	Temperature/Cure	
	┢	4	nk/Ripple	/Wave		Burrs		-1	ion Incomplete/Un	ngualified	Г	Part Lost/Mi		-	Weld	
	-	Crimp/Kink/Ripple/Wave			-	Contamination			tions Incomplete/U		 -	Part Moved			Wrong Stock Pulled	
		Cuffs Crushing			-	Countersink		-1	gned/off center			Positioned V	Vrong		•	
	一	Heat Treat				Cut Too Short		Mislab	-			Power Loss/			Other	
		4	Inspection Strip in Tube			Drawing		Misrea	d							
	Г	4 '	· —			Drill Holes		Off-set								
	Γ	-i '	Sequence			Finish		Out of	Calibration							
		Wave/Tv	vist in Tub	е		Fit/Function		Out of	Sequence							

Picklist Print

September-11-14 12:03:12 PM

Work Order ID: 124353 *124353*

Parent Item:

D3631-1

D3631-1

Parent Item Name: Washer

Start Date: 9/10/14

Required Date: 9/10/14

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A New Issue 07-07-28 JLM Verified By:EC

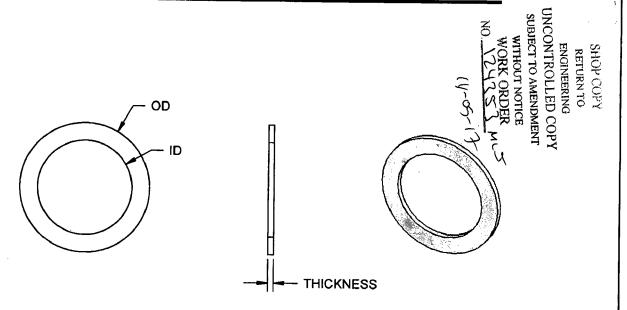
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
95606A170		Purchased	No		110	Each	0.0000	1	50			
95606A1	70							**	100	M	19/23	3 /20

DQA:			Date: _										DART
QA Closed:		г	Date:			WORK ORDER NON-	·CC	ONFO		Wai	k Order up	date only	AEROSPACE
JA Closeu.		L	Jate.				1			-	<u>;</u>	<u></u>	
Work Orde	r:					DISPOSITION			AGAINST	DEP	ARTMENT	PROCESS	
					_	Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	o.					Scrap		1	Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo					Suspected Unapproved	ected Unapproved Large Fab Composit					Supplier	
Root					Descr	iption of work order update		Initial Action			Sign &		
Cause	D	ate S	tep	Qty		or non-conformance	l	ief Eng	Description	ļ	Date	Verification	QC Inspector
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Offset/Setup													
Process													
Supplier													
Training			1										
Transport		İ].				·				
Unapproved					Ĺ <u>, , , , , , , , , , , , , , , , , , , </u>	- W							
							FAI	ULT CA	TEGORY				
Landir	ng Gear				_	General	_	1 .				Г	
	_	ding			<u> </u>	Bend	<u> </u>	4	Program	-	Outside Dim	⊢	Pressure/Forced
		tre Not C	Concer	itric	<u> </u>	BOM/Route	<u> </u>	Grain		\vdash	Over/Under	_	Set-up
ļ	Cra				<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred	⊢	Temperature/Cure
	_	np/Kink/l	Ripple	/Wave		Burrs	<u> </u>	4 '	ion Incomplete/Unqualified	-	Part Lost/Mi	ssing	→ Weld
	Cuf				<u> </u>	Contamination	<u> </u>	4	tions Incomplete/Unclear	_	Part Moved	L	Wrong Stock Pulled
	Crushing			_	Countersink		•	gned/off center	$\overline{}$	Positioned V		Jorhan	
	Heat Treat			<u> </u>	Cut Too Short	\vdash	Mislabe			Power Loss/	surge [Other	
	Inspection Strip in Tube				Drawing	<u>_</u>	Misrea		_				
		rks/Chatt			<u> </u>	Drill Holes	<u> </u>	Off-set		-			
		ning Sequ				Finish	<u> </u>	4	Calibration	-			
	Wa	ve/Twist	ın Tub	e		Fit/Function	<u>L</u> .	Out of:	Sequence				

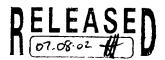


DESIG	N B	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHEC	PH	APPROVED	D3631	REV. A SHEET 1 OF 1
DATE	07.0	5.16	WASHER	SCALE NTS
REV		DATE	DESCRIP	TION
A		07.05.16	NEWISSUE	

SPECIFICATION CONTROL DRAWING



D3631-X WASHER



PART NUMBER	OD	ID	THICKNESS	MATERIAL	SUPPLIER
D3631-1	0.688	0.500	0.031	NYLON	McMASTER-CARR P/N: 95606A170

NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25843

Purchase Order Date 9/18/2014 PO Print Date 9/18/2014

Page Number 2 of 3

Order From:

MCMASTER-CARR SUPPLY CO, P.O. BOX 7690 CHICAGO, IL 60680-7690 US

VU-MCM001

Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 **CANADA**

Contact Name

Vendor Phone

330 995 5500

Ship To Contact Ship To Phone

Ship Via:

95606A170

Ship Acct:

3

Purolator ground ppd

9/22/2014

AS PER DWG D3631 REV. A

Washer

B124353

MCMASTER P/N: 95606A170

Buyer

Terms

FOB

Currency

Chantal Lavoie

10127-2607

Customer POID

Customer Tax #

Net 10 USD

FCA - (Free Carrier)

Yes

9/22/2014

100.00 Each \$0.10

\$10.40

Line Total:

\$10.40

63215K34

Bearing

9/22/2014 Yes

9/22/2014

20.00

Each

\$17.24

\$344.80

AS PER DWG D2611 REV. C

B124478

MCMASTER P/N: 63215K34

Line Total:

\$344.80

\$54.00

92311A599

SET SCREW

9/22/2014

9/22/2014

Yes

250.00

Each

\$0.22

AS PER DWG D2712 REV. B

B124450

MCMASTER P/N: 92311A599

Note:



200 Aurora Industrial Pkwy Aurora OH 44202-8087 330-995-5500 cle.sales@mcmaster.com Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada Purchase Order PO25843

Page 1 of 1

Order Placed By Chantal Lavoie 09/19/2014

McMaster-Carr Number 1285138-01

Lin	е	Product	Ordered	Shipped	LNS	111
2	59915K274	PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B124299	10 Each	10	3 - 481 - 01 06 - 14 K274 10 EA	2
4	63215K34	Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B124478	20 Each	20	3 - 482 - 03 07 - 38 K34 20 EA	۷
1	2458K14	Carbon-Fiber Insert Ball Joint Rod End 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	4 Each	4	3 - 483 - 03 04 - 72 K14 4EA	1
(3	95606A170	Nylon 6/6 General Purpose Flat Washer, Off-White, 7/16" Screw Size, 69" OD, 02"04" Thickness, Packs of 100 Your Part Number: B124353	1 Pack	1	2 - 623	3
5	92311A599	18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 Your Part Number: B124450	5 Packs	5	2 - 696	5

Dart Aerospace Ltd

EXP



5 lbs 5 lines

FW1W8P32 09/19/2014 12:55/13:07 908 Cycle 44





